

Work Order ID 71663

October-14-11 11:47:53 AM

71663

Page 1

Item ID: D3255-042

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Access Panel Assembly

Start Date: 7/07/11

Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/11

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD
Batch: 4115778 2-Grind Welds Flush

11/10/18 (2x)

110

QC10- Inspect visual per QSI004- ground welds

0.00

110

QC

Memo

0.00

Quality Control

8-10/18

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

8-10/18

(+2)

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October-14-11 11:47:53 AM

Item ID: D3255-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Access Panel Assembly

Start Date: 7/07/11 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 7/21/11 Req'd Qty: 4.00 *4*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

2X DM 11/10/18

M 118489

3200 F

3:50

4:20

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

2 4 11/10/19

150

Small Fab

0.00

150

Small Fab

Memo

0.00

Small Fab

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg
D3255A/R 736 DOW CORNING ADHESIVE
Batch: 1116664

11/10/20

2

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Item ID: D3255-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Access Panel Assembly

Start Date: 7/07/11 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 7/21/11 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 178

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

5 11/10/20

(12)
212

11/10/20 sl(2)

11/10/20
mf
11-10-20

Picklist Print

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Work Order ID: 71663

Parent Item: D3255-042

Parent Item Name: Access Panel Assembly

Start Date: 7/07/11

Required Date: 7/21/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-2 Panel		Manufactured	No			100	Each	6.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
					71676	6							
D3255-3 Cap		Manufactured	No			150	Each	14.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		14							
					72152	14							
D3255-5 Gasket		Manufactured	No			100	Each	9.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		9							
					72118	9							

[Signature] 11/10/17

[Signature] 11/10/17

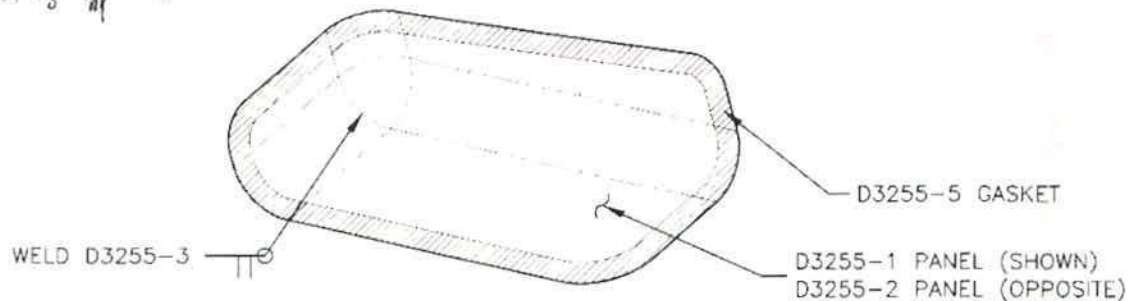
[Signature]

[Signature] 11/10/19

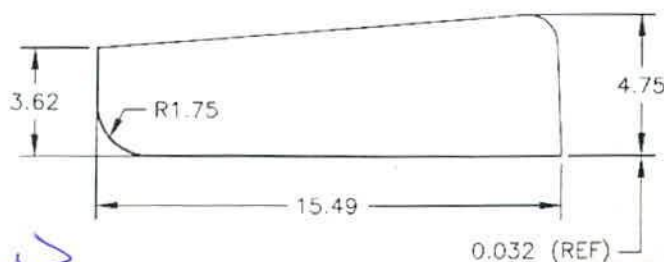
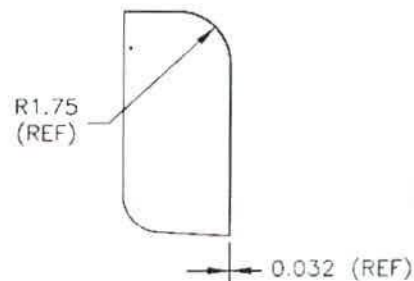
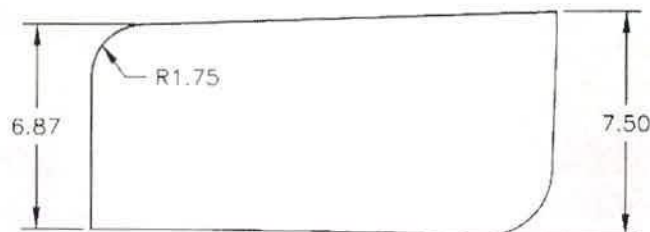
[Signature]

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:1
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

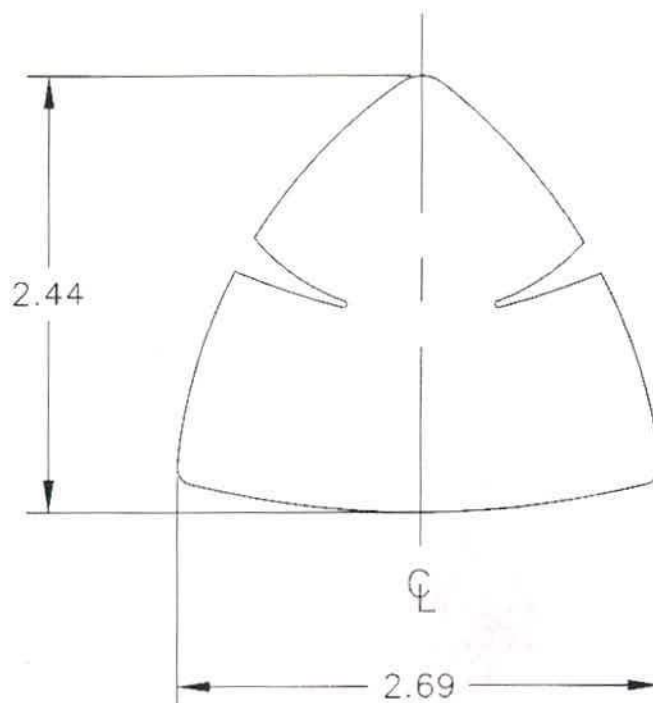
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DESIGN 71	DRAWN BY 17	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 04.12.06		TITLE TITLE	SCALE 1:1

05-01-18 #



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

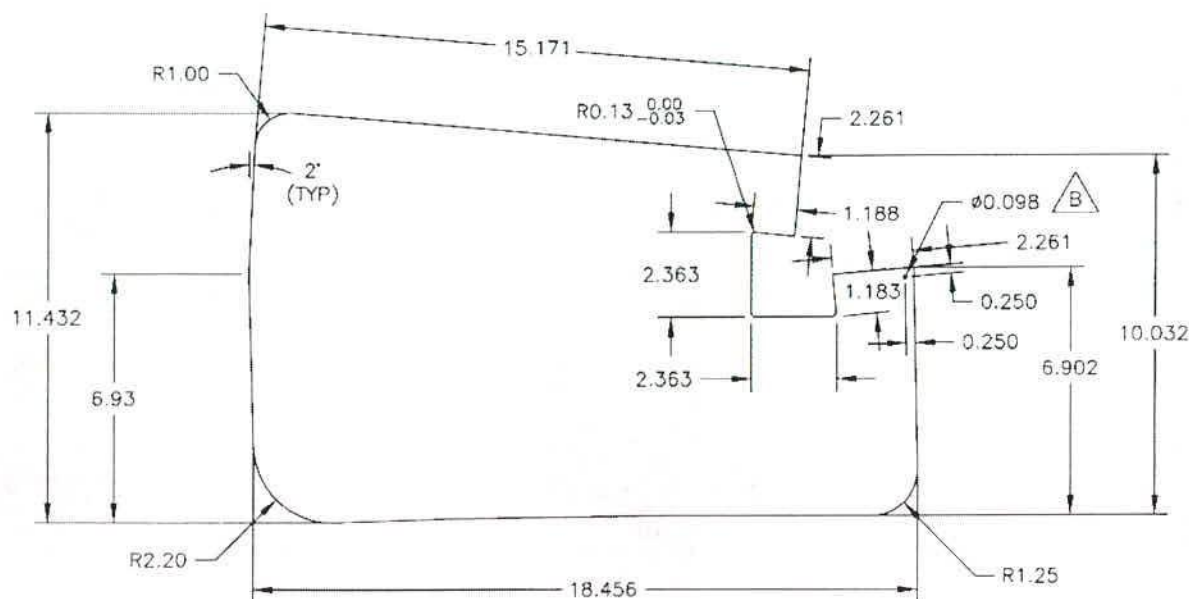
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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CHECKED 16	APPROVED 17	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

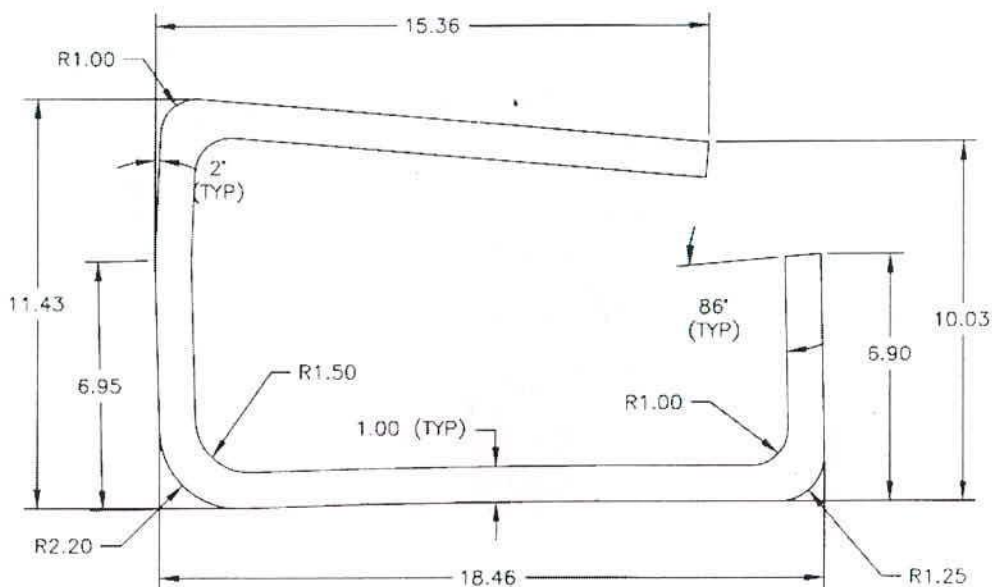
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED 11	APPROVED 11	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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